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ASH GROVE CEMENT WEST, INC.

Inter-Office Memorandum

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To Kenneth J. Rone, Jr.

Copies to Dick Cooke

Date August 1, 1984

From Nathan A. Fernow

Subject Grinding Aid & Cement Flowability

During the past four (4) years, we have had only a few problems with the flowability of the cements manufactured in Seattle.

In the past, the first indications of a problem would come from Portland during railcar unloading. The trip over the rails and the loss of some heat, combined to magnify a small or non-evident problem. This would give us time to investigate the situation and avoid any direct customer inconvenience.

The problems were discovered to be a lower than normal amount of grinding aid in the cement for the majority of the complaints. There were some samples that demonstrated poor flowability that had enough grinding aid. We concluded that this cement lost its flowability over the extended length of time it was in storage.

This problem did not only happen with one brand of grinding aid, but with the group that has glycol as a major component. We switched to amine compound based products and have not had any recurrence of the problem.

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